

Work Order ID 69127

Tuesday, May 03, 2011 10:06:56 AM



Page 1

Item ID: D3182-1

Revision ID:

Item Name: Hinge

Start Date: 5/3/2011 Start Qty: 4.00

Accept



Setup

Start



Stop



Required Date: 5/9/2011 Req'd Qty: 4.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:



Date: 11-05-3

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3182	Rev A

100



FLOW WATER JET

Waterjet

Memo

FLOW CNC Waterjet

304.125

I-Cut as per Dwg D3182 Dwg Rev: A Prog Rev: A U2-
Deburr if necessary

B11-5-10

(6)

110



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

Quality Control

0.00

B11-5-10

120



QC8- Inspect parts - second check

QC

Memo

Quality Control

0.00

S. U. C. S. T. U.

(6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69127

Tuesday, May 03, 2011 10:06:56 AM



Page 2

Item ID: D3182-1

Accept



Setup Start



Revision ID:

Item Name: Hinge

Start Date: 5/3/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 5/9/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

130



Small Fab

Small Fab

Operation
Description

Small Fab

Memo

Deburr if necessary

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

0.00

150



Packaging

Packaging

Identify as per dwg & Stock Location: WA

0.00

0.00

Memo

*****STOCK IN BASKET CELL*****

SAD

11-05-13

(6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Work Order ID 69127

Tuesday, May 03, 2011 10:06:56 AM



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Item ID: D3182-1

Accept



Setup

Start



Revision ID:

Item Name: Hinge

Stop



Start Date: 5/3/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 5/9/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center ID

160



QC

Quality Control

Operation
Description

QC21- Final Inspection - Work Order Release

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

11/5/16 JJ

Memo

0.00

MF
11-05-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, May 03, 2011 10:07:04 AM

Page 1

Work Order ID: 69127



Parent Item: D3182-1



Parent Item Name: Hinge

Start Date: 5/3/2011

Required Date: 5/9/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP A 03.01.29 New issue KJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA 		Purchased	No			100	sf	161.0000	0.0596	0.250947 			<i>(B11-5-10)</i>

304/316 0.125 Sheet

Location	Loc Qty	Loc Code
MAT020	161	
117494	161	

117494

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	69127
Description: Hinge	Part Number:	D3182-1
Inspection Dwg: D3182	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	1B	Audited by:	8	Prototype Approval:	N/A
Date:	11-5-10	Date:	11/25/10	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.10.12	New Issue	KJ/JLM	
B	08.01.16	3.718 was 3.178	KJ/EC/DD	

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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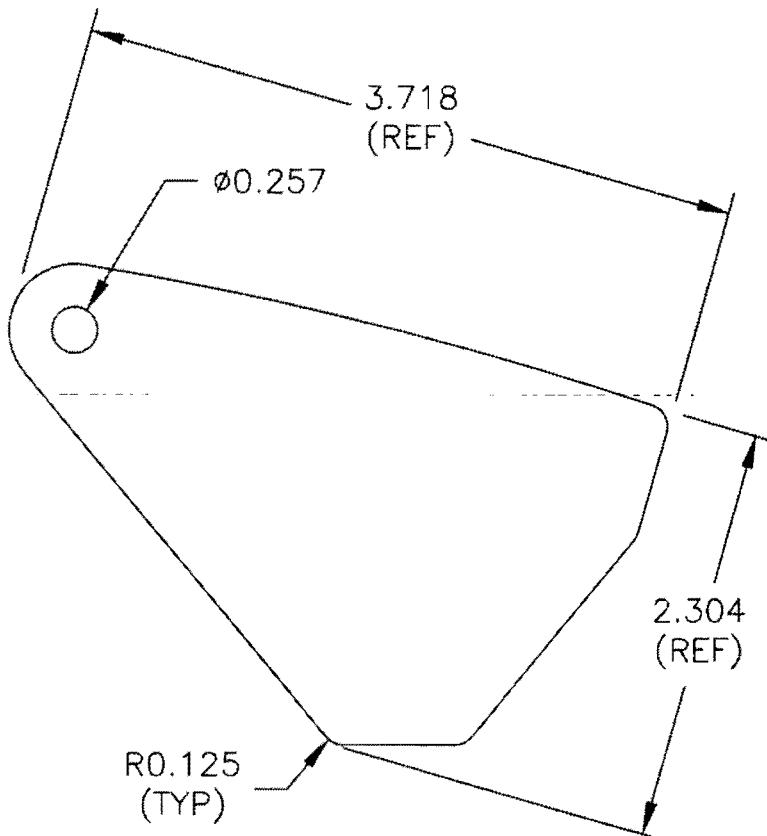
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
		D3182	SHEET 1 OF 1
DATE		TITLE	SCALE
03.01.21		HINGE	1:1
A	03.01.21	NEW ISSUE	

RELEASED
03.01.21 CP



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 011-053

D3182-1 HINGE

- 1) MACHINE D3182-1 PER DART DWG "D3182-1.DWG"
- 2) MATERIAL: AISI 304/316 SS SHEET 0.125 THICK
(REF DART SPEC. M304S11GA)
- 3) FINISH: NONE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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